

Work Order ID 66596

Tuesday, February 22, 2011 1:28:07 PM



Page 1

Item ID:	D3186-4	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Spacepod Door, RH					
Start Date:	2/22/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	2/25/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-02-20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3186	Rev E								

100		Small Fab		0.00					
Small Fab		Memo		0.00					
Small Fab		1-Trim door to fit spacepod before drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)							
110		QC5- Inspect part completeness to step on W/O		0.00					
QC		Memo		0.00					
Quality Control									
120		Identify as per dwg & Stock Location: 50104657		0.00					
Packaging		Memo		0.00					
Packaging									

N/A

N/A

customer ordered door only - no trim no holes
5/6 104657

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66596

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Tuesday, February 22, 2011 1:28:07 PM

Item ID: D3186-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Door, RH

Start Date: 2/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/y/14

u/y/14

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Tuesday, February 22, 2011 1:28:14 PM

Page 1

Work Order ID: 66596



Parent Item: D3186-4



Parent Item Name: Spacepod Door, RH

Start Date: 2/22/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00


Comments:

IPP Rev:A New Issue 07-01-11 EC

IPP rev.B revD 07.03.07 ec

IPP Rev:C

10-08-11 added trim door before drilling DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2M  SPACEPOD DOOR RH		Manufactured	No			100	Each	0.0000	1	1			



66593

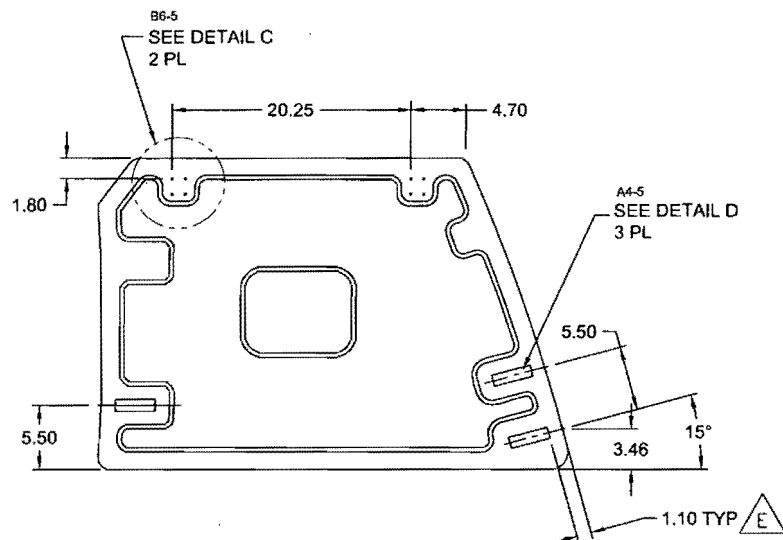
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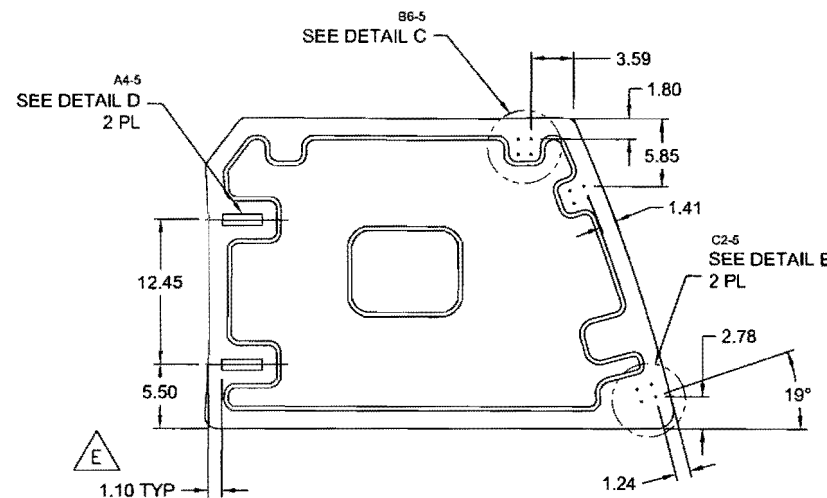
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NOTE: Date & initial all entries



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. *66596*

09-02-22

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

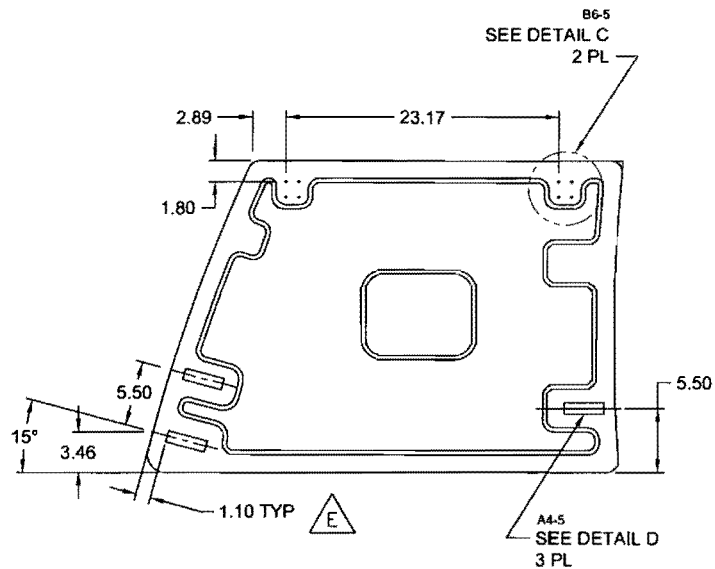
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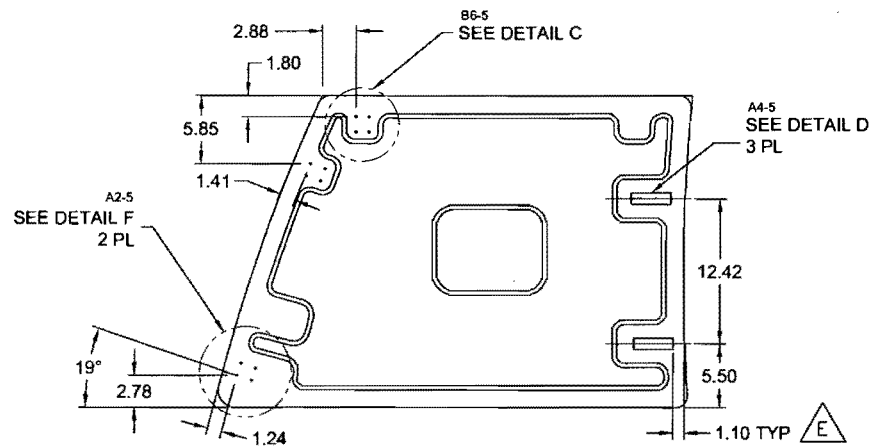
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NOTE: Date & initial all entries



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2008-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

W/O 46584

DESIGN	DS	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
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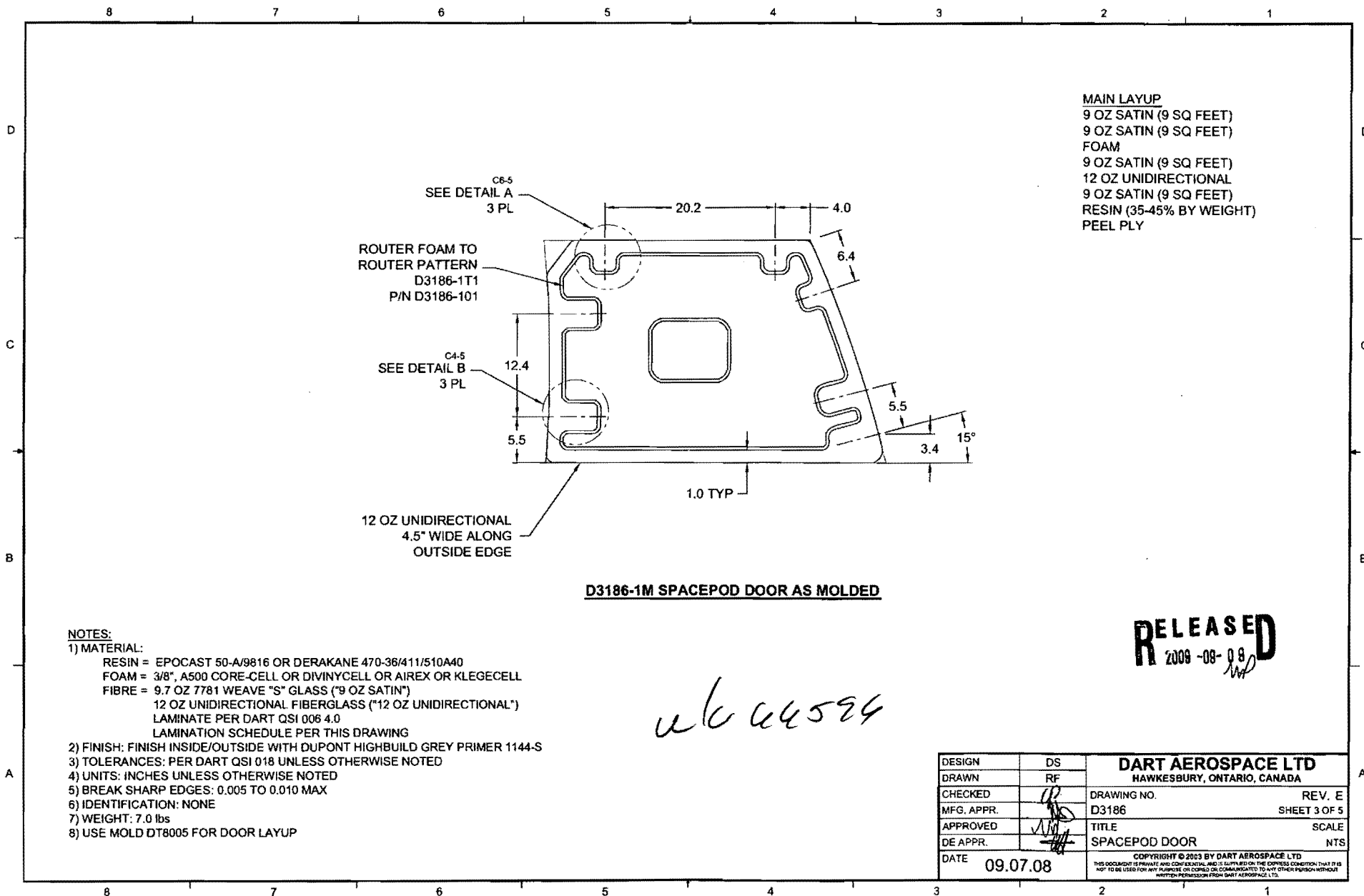
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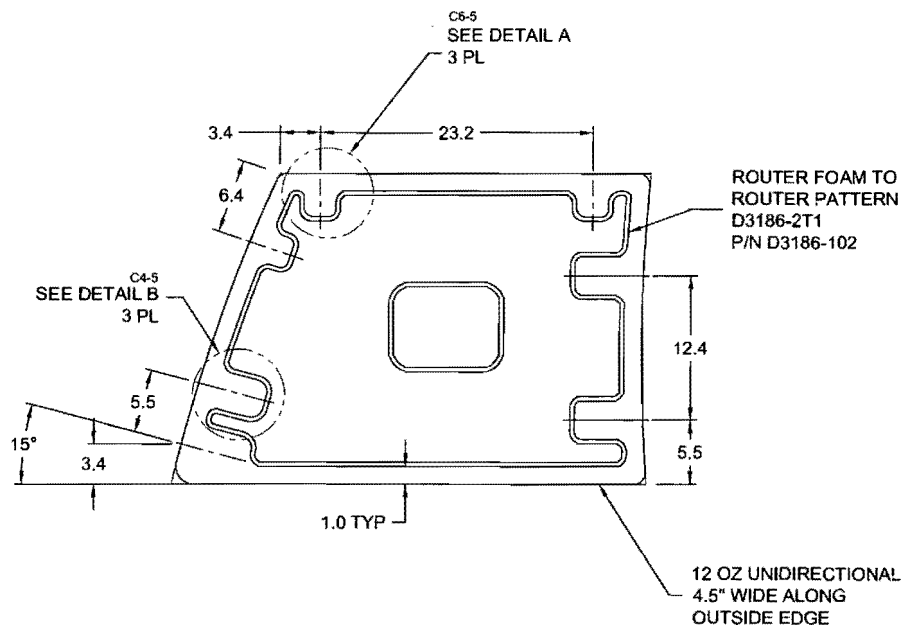
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NOTE: Date & initial all entries

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/41/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 7.0 lbs
8) USE MOLD DT8006 FOR DOOR LAYOUT

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
2008-09-09
[Signature]

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3186 TITLE SPACEPOD DOOR SCALE NT DATE 09.07.08
DRAWN	RF	
CHECKED	JP	
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	

W/O:		WORK ORDER CHANGES					
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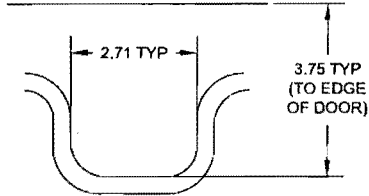
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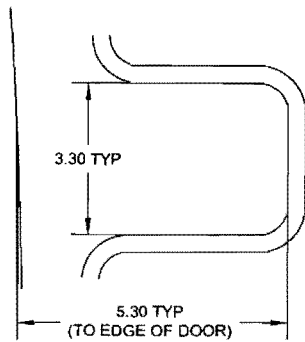
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D
C
B
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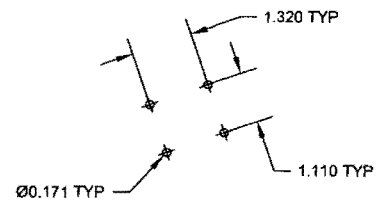
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C
B
A



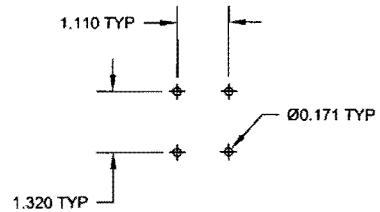
DETAIL A D6-3
SCALE 4X D4-4



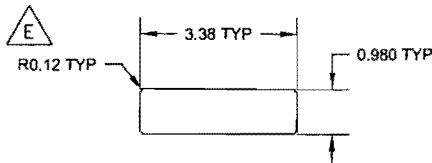
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

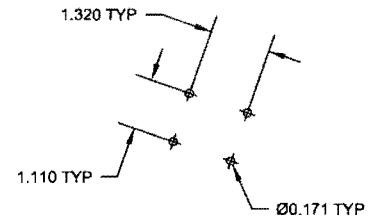


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

u/b 66596

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
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DE APPR.		SPACEPOD DOOR	NTS
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8 7 6 5 4 3 2 1

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